

Date: Wednesday, 25/06/2008 12:00:03 PM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services		<b>Drawing Name</b>	: STEP SPACER		
<b>Job Number</b>	: 40087B			<b>Part Number</b>	: D2322	
<b>Estimate Number</b>	: 10354			<b>Drawing Number</b>	: D2322 REV C	
<b>P.O. Number</b>	:			<b>Project Number</b>	: N/A	
<b>This Issue</b>	: 25/06/2008		<b>S.O. No.</b>	:		
<b>Prsht Rev.</b>	: NC			<b>Drawing Revision</b>	: C	
<b>First Issue</b>	: / /		<b>Type</b>	: SMALL /MED FAB		
<b>Previous Run</b>	: 37925B			<b>Material</b>	:	
<b>Written By</b>	:			<b>Due Date</b>	: 07/07/2008	
<b>Checked &amp; Approved By</b>	: <u>JUL 08.6.25</u>			<b>Qty:</b>	12	<b>Um:</b> Each
<b>Comment</b>	: Est Rev:A New Issue 05-11-07 JLM Est Rev:B Now on Waterjet 06-07-03 JLM					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S040	2024-T3 .040 sheet
		 
		<b>Comment:</b> Qty.: 0.2132 sf(s)/Unit Total : 2.5578 sf(s) Material: 2024-T3 sheet (QQ-A-250/4) 0.040" Thick (M2024T3S.040) Identify as D2322 Batch: <u>105572</u> HB 8-7-3
2.0	WATER JET	FLOW WATER JET
		 
		<b>Comment:</b> FLOW WATER JET 1-Cut as per Dwg D2322 Dwg Rev: <u>C</u> HB 8-7-3 Prog Rev: <u>C</u>
		14
		2-Deburr if necessary HB 8-7-3
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		 
		HB 8-7-3
		<b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK
		 
		S 08/07/08 NC
		<b>Comment:</b> SECOND CHECK
5.0	BRAKE NC	NC BRAKE
		 
		<b>Comment:</b> NC BRAKE Form as per Dwg D2322
		HB 08/07/07
		14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP SPACER

Job Number: 40087B

Part Number: D2322

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



S 08/07/08 X/100

Comment: INSPECT WORK TO CURRENT STEP

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



(14)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



L 08/07/08 (14)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

SYLVE

P 08/07/08 (14)

10.0 QC21

FINAL INSPECTION/W/O RELEASE



08/07/10 JJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



UMF 08-07-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	40087B
Description: Step Spacer	Part Number:	D2322
Inspection Dwg: D2322	Rev: C	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article Prototype

Measured by:	B	Audited by:		Prototype Approval:	N/A
Date:	8-7-3	Date:	08/07/08	Date:	N/A

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A	04.10.12	New Issue P/O D2582	KJ/JLM	SJM

**DART**

DESIGN BW	DRAWN BY <i>CJ</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>KE</i>	APPROVED <i>JMF</i>	DRAWING NO. D2322
DATE 98.09.29	TIME	REV. C SHEET 1 OF 1
A	94.10.14	SCALE 1:2
C	98.09.29	CHANGES PER NCR 001

**RELEASED**  
*18.10.98 DS***UNDER REVIEW**

01.03.15 GP

DESIGN OK, BUT CHECK WITH  
ME BEFORE MANUFACTURE

OK GKP 11/11/98

Ø0.128 (TYP 12 PLACES)

Ø0.125  
(TYP 4 PLACES)

KE 49.05.06

GRAIN DIRECTION

FLAT LAYOUT

